

Date: Tuesday, 11/11/2008 10:18:12 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 43303	
Estimate Number : 12773	
P.O. Number :	Part Number : 41232 200 002 001
This Issue : 11/11/2008 S.O. No. :	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42265	Material :
Written By : <i>JLM 08.11.11</i>	Due Date : 18/11/2008 Qty: 12 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-03-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3H1375	2024-T3 Hex Bar 1.375"
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Comment: Qty.: 0.4550 f(s)/Unit Total : 5.4596 f(s)

Not removed from computer 08/11/12

2024-T3 Hex Bar 1.375"

Batch: M106680 08/11/12

12 pcs

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg 41232-200-0021

TURN BORE TAP DRILL 45/64" AND TAP 3/4"20

12 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

12 pcs

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA687 Rev: AA & Dwg 41232-200-002 Rev: A

2-Debur

J.F.

08/11/17

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F.

08/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 41232-200-002-001 PAR #: N/A Fault Category: Prod. Mgmt. NCR: Yes No DQA: NA Date: 08.11.27
 (41232-200-001-001/-002)
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 08/11/28

NCR: <u>43303</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/17	4.0	1.20" Hole is Drill thru Hole is suppose to be just on one side.	<i>[Signature]</i>	Scrap and Destroy <u>no replace</u> Qty <u>(10)</u>	J.F. 08/11/17	<i>[Signature]</i> 08/11/17	<i>[Signature]</i> 08/11/17	<i>[Signature]</i> 08/11/17
		R.C. operator placed part on wrong orientation - Laced Attenuator						

NOTE: Date & initial all entries

Date: Tuesday, 11/11/2008 10:18:12 AM
User: Jean-Luc Menard

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 43303

Part Number: 41232 200 002 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/11/17

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 7613

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

CL 08/11/18 (11)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

8/11/26 (11)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 09/11/26 (11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 364

8/11/26

508 X(11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



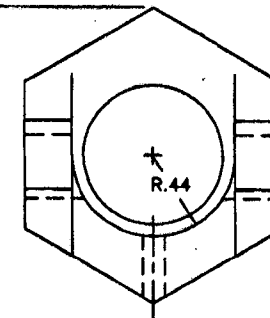
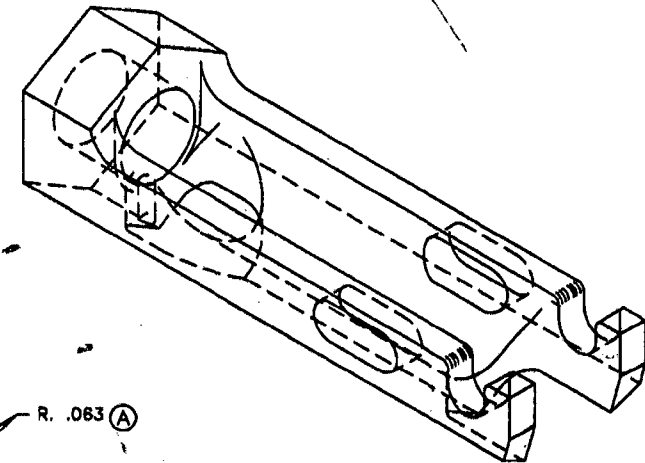
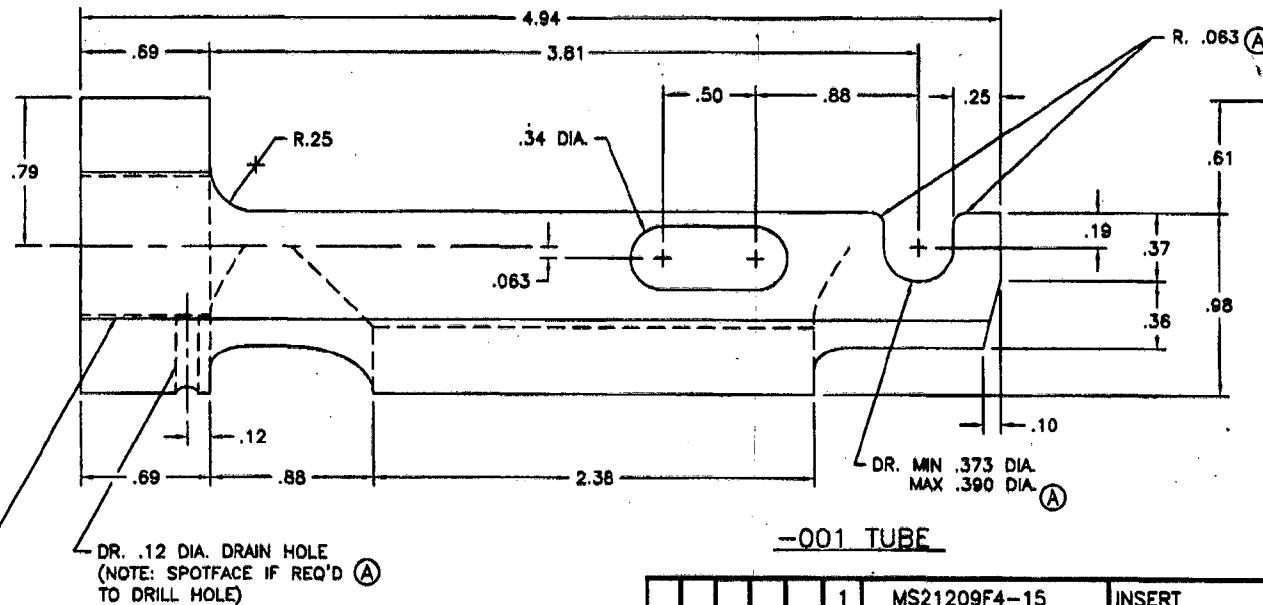
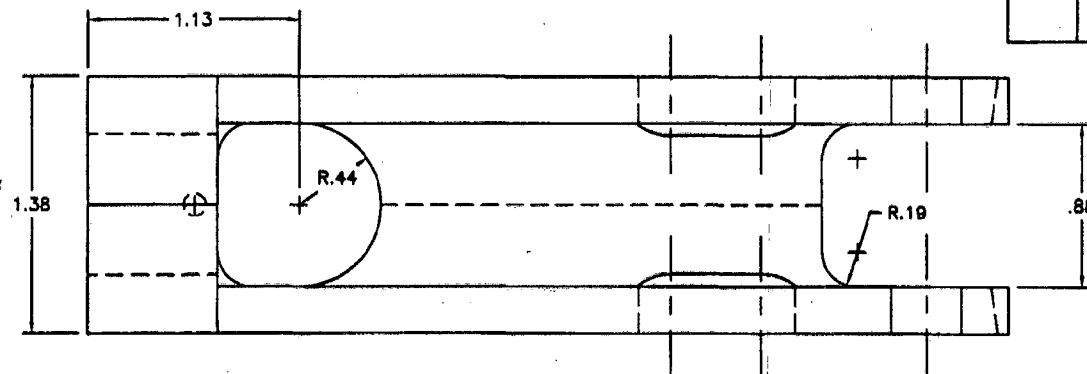
Comment: FINAL INSPECTION/W/O RELEASE

08/11/27 (11)

Job Completion



mt 08-11-28



w/o 43303

-001 TUBE

REVISION			
LETTER	DRFTSMAN	DATE	DESCRIPTION
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.
MINOR CHANGE - FAR 21.95		CHECK	D. MURPHY 2/17/03

3/4"-20 THD,

⚠ ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

1	MS21209F4-15	INSERT			
	-005	PIVOT ARM	⚠	1.00 DIA. x 3.56	2024-T4, T351 ALUM.
	-003	LATCH	⚠	1.11 x 3.50	2024-T4, T351 ALUM.
	-001	TUBE	⚠	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL
NO. REQ'D PER ASSY					
LIST OF MATERIAL					
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2	41232-200-001				
NEXT ASSEMBLY					
UNLESS OTHERWISE SPECIFIED X.0.1 X.0.0.03 X.0.0.010 ANGLES 2.1/2					
DRFTSMAN D. NELSON 2/18/02 CHECK D. MURPHY 2/18/02 STRESS FINISH HEAT TREAT FRESH					
TITLE STEP ACTUATOR COMPONENTS DWG. SIZE C SCALE 2:1 DWG. NO. 41232-200-002 SHT 1 OF 3 REV. A					

Eric Aviation, Inc.

DART AEROSPACE LTD		Work Order: 43303
Description: Tube		Part Number: 41232-200-002-00
Inspection Dwg: 41232-200-002	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.690	± 0.030	.693				
4.94	± 0.030	4.945				
3/4-20		3/4-20				
.44 Radius	± 0.030	.439				
.61	± .030	.609	✓			
.88	± .030	.884	✓			
.063	± .010	.063	✓			
1.38	± .030	1.375	✓			
.69	± .030	.690	✓			
.12	± .030	.126	✓			
Ø .12		.126				
.98	± .030	.971	✓			
.25	± .030	.257	✓			
.36	± .030	.349	✓			
.37	± .030	.374	✓			
.10	± .030	.100	✓			
R.063	± .010	R.063	✓			
.373	± .017	.374	✓			
Ø .34	± .030	Ø .339	✓			
R.25	± .030	R.250	✓			
2.38	± .030	2.384	✓			
3.81	± .030	3.808	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval:
Date: 08/11/12	Date: 08/11/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe-Claire, Q C H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certifié

Certifié NADCAP certified

PACKING
SLIP

70407

25-Nov-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:

PURCHASE ORDER/

214699/7613

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	11	11	41232-200-002-001	B43303

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

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Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certifié

Certifié NADCAP certifié

FACTURE**INVOICE****70407 Rev.00**

25-Nov-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. DE COMMANDE:**PUI CHASE ORDER/ 214699/7613****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER	DESCRIPTION	PRIME PRICE	EXTENSION
1	11	11	41232-200-002-001	B43303	\$0.00	\$0.00
			MINIMUM CHARGE			\$100.00
			<i>Sosluo</i>		SUB TOTAL:	\$100.00
					TPS/GST:	\$5.00
					TVQ/PST:	\$0.00
					TOTAL AMOUNT DUE:	\$105.00

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

CERTIFICAT DE CONFIRMATION EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS*En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.**Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.*

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
Telephone: (514) 429-7777 Fax (514) 429-5108
Certifié ISO 9001-2000 certified
approuvé NADCAP approved

70407

25-Nov-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**

**NO. DE COMMANDE: 2 4699/7613
PURCHASE ORDER/**



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	11	11	41232-200-002-001 B43303	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2

*S
cosu be*

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

